



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3179-041
Job Sheet 202279-A



Part No: D3179-041

Job Qty: 6 pcs

Part Name: Litter Tie Down (Non-Locking)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/19

Job Tracking No:

Due Date: 11/18/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV E IPP A1 03.01.09 Added Acid etch end alodine RF IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP REV:C AS PER REV D JLM 13-05-24 VERIFIED BY:DD IPP Rev:C 08-12-10 add part list DD verified
by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
170	QC 3	6 pcs	11/18/19	0.00	0.00		QC 3 - 10		
							QC 3 - 13		
							QC 3 - 15		
							QC 3 - 17		
							QC 3 - 18		
							QC 3 - 2		
							QC 3 - 28		
							QC 3 - 3		
							QC 3 - 30		
							QC 3 - 34		
							QC 3 - 36		
							QC 3 - 41		
							QC 3 - 51		
							QC 3 - 58		
							QC 3 - 59		
							QC 3 - 68		
							QC 3 - 9		
							QC 3 - 40		
							QC 3 - 19		
							QC 3 - 43		
							QC 3 - 24		
							QC 3 - 61		
							QC 3 - 81		
180	Small Fab - 2 - B4B	6 pcs	11/18/19	0.00	0.89		Small Fab - 1 - B4B		DAS 58 9-89 JAN 03 2020
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		

190 QC 5	6 pcs	11/18/19	0.00 0.00	Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
200 Packaging 3-1 - Stock - B4B	6 pcs	11/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	6 pcs	11/18/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS
40
JAN 06 2020 9-89

DAS
84
9-89

ST 225

DAS
21
JAN 07 2020

Part Op **170** - (QC3- Inspect Part Finish)
 Descriptions: **180** - (Small Fab) Assemble as per Dwg D3179
190 - (QC5- Inspect part completeness to step on W/O)
200 - (Identify as per dwg & Stock Location: _____)
210 - (QC21- Final Inspection - Work Order Release)

013718

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2372	Quick Release	12 pcs (2 ea)	180-Small Fab - 2 - B4B	S236838
D2444	Pip Pin Assembly	6 pcs (1 ea)	180-Small Fab - 2 - B4B	S244097
MS21042L3	Nut	6 Ea (1 ea)	180-Small Fab - 2 - B4B	S218152
MS27039-1-13	Screw	6 Ea (1 ea)	180-Small Fab - 2 - B4B	S124326
NAS1149D0332J	Washer	18 Ea (3 ea)	180-Small Fab - 2 - B4B	S244488

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
180-Small Fab - 2 - B4B	D2372	12	50	0
	D2444	6	22	0
	MS21042L3	6	2,466	0
	MS27039-1-13	6	286	0
	NAS1149D0332J	18	3,668	0

Part Specifications

Specifications could not be found.



289 Great Road
Suite 105
Acton, MA 01720
T:(800) 649-5289
F:(978) 263-0785
www.nqa.com

Client: Dart Aerospace Ltd
Complete Address: 820 McTavish Rd, Calgary, AB
Report Number: #19903

Date: 2-3 Dec 2019

AUDIT PLAN

- Audit Scope:** The audit was conducted at the locations and associated organization units identified with the address listed above and encompass the activities/processes associated with this audit plan.
- Audit Objectives:** The determination of the conformity or continued conformity of the client's management system in accordance with the audit criteria, statutory, regulatory, and contract requirements; and the evaluation of the management system's overall effectiveness in meeting those specified objectives.

Auditor:	André J. Roy	Company Representative:	M. Daviau			
Time	Monday Dec 2	Tuesday Dec 3				
08:00	Opening Meeting	Report writing				
08:30	Management process Scope review, Roles, responsibilities, Quality Policy, Planning, Risks, KPIs and trends, Changes, Communications, Linkages with Hawkesbury facility QMS and documentation. Clauses 4.0, 5.0, 6.0, 7.0					
9:30	Design and Development Design and development planning, Inputs, Controls, Outputs, Changes Risk Management, Obsolescence Clauses 8.1, 8.3				Closing Meeting	
10:00		Day end				
12:00	LUNCH (on site)					
12:30	Design and Development (Cont'd)					
13:30	Management process Infrastructures, Environment, Org. knowledge, Competence, Awareness Clauses 7.1, 7.2, 7.3					
14:30	Audit Trail Follow-up Previous NCRs review NCR 2016-03, 2016-04, 2018-03					
15:00	Daily Debrief					
16:00	Day end					
18:30-21:00	Report writing					
Total Hours	7.5 (+ 2.5)	0.5 (+1.5)				
Audit trails will be developed based upon identified risk throughout the audit and as such timings and content may be subject to change.						

NOTES: Do not add generalized/vague activity entries. Audit days are 8 hours in duration. No more than 8 hours can be claimed in any given calendar day (reference ANAB Heads Up 38). Audit time DOES include the opening and closing meeting(s) as well as any daily debriefs. Include mandatory topics such as OASIS Administrative Verification, Logo/Artwork usage review, etc. Audit time DOES NOT include: auditor arrival and setup time (auditor preparation); auditor caucus; lunch, "working lunch", breaks; travel time; off-site report writing/editing time, etc. End of last activity/departure is required to show when the audit day ended. Total on site time and report writing time MUST equal the amount of time specified on the Work Order. Report writing is required to be performed "on-site" unless otherwise arranged with the office. Report writing is not considered "auditing time".



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3179-041
Job Sheet 202279



Part No: D3179-041

Job Qty: 16 pcs

Part Name: Litter Tie Down (Non-Locking)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/19

Job Tracking No:

Due Date: 11/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP A1 03.01.09 Added Acid etch end alodine RF IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP REV:C AS PER REV D JLM 13-05-24 VERIFIED BY:DD IPP Rev:C 08-12-10 add part list DD verified
by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	16 pcs		11/18/19	0.00	1.32	Bandsaw - 1		DJP 19-11-04
110	HAAS 4 Axis - B4B	16 pcs		11/18/19	0.37	29.09	HAAS - 1 - B4B		DAS 19/11/5
							HAAS - 2 - B4B		52
							HAAS - 3 - B4B		9-89
							HAAS - 4 - B4B		
120	QC 2	16 pcs		11/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		DAS
							QC 2 - 52		52 19/11/5
							QC 2 - 57		9-89



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S229184



Part: D3179-041

Job No: 202279

Serial No/Batch: S229184

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/04/19

Plex 10/23/19 1:35 PM Dart.lajeunesse.marie

130 QC 8	16 pcs	11/18/19	0.00	0.00	QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	16 pcs	11/18/19	0.00	1.30	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	

19/11/7

BEB19-11-08

DAS
23
9-89

						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	QC 7	16 pcs	11/18/19	0.00	0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
						QC 7 - 76	
						QC 7 - 79	
160	Powdercoat - 1 White GI(A)- B4B	16 pcs	11/18/19	0.00	0.95	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
170	QC 3	16 pcs	11/18/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	

						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
180	Small Fab - 2 - B4B	16 pcs	11/18/19	0.00	2.38	Small Fab - 1 - B4B	
						Small Fab - 2 - B4B	
						Small Fab - 3 - B4B	
						Small Fab - 4 - B4B	
						Small Fab - 5 - B4B	
						Small Fab - 6 - B4B	
						Small Fab - 7 - B4B	
						Small Fab - 8 - B4B	
190	QC 5	16 pcs	11/18/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
200	Packaging 3-1 - Stock - B4B	16 pcs	11/18/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	

Plex 10/23/19 1:35 PM Dart.lajeunesse.marie

					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	16 pcs	11/18/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op **100** - (Bandsaw) Cut blanks: 12.150" longDescriptions: **110** - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA297 Rev: AA & Dwg D3179-1 Rev: E**120** - (QC2- Inspect parts off machine FAI/FAIB)**130** - (QC8- Inspect parts - second check)**140** - (Chemical Conversion Coat per QSI005 4.1)**150** - (QC7-Inspect Chemical Conversion Coat)**160** - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____**170** - (QC3- Inspect Part Finish)**180** - (Small Fab) Assemble as per Dwg D3179**190** - (QC5- Inspect part completeness to step on W/O)**200** - (Identify as per dwg & Stock Location: _____)**210** - (QC21- Final Inspection - Work Order Release)

5229069 X1

Job BOM

S157836

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	16.2000 ft (1.0125 ea)	100-Bandsaw - 1	S216374
D2372	Quick Release	32 pcs (2 ea)	180-Small Fab - 2 - B4B	S188318
D2444	Pip Pin Assembly	16 pcs (1 ea)	180-Small Fab - 2 - B4B	S176308 X2
MS21042L3	Nut	16 Ea (1 ea)	180-Small Fab - 2 - B4B	S218152
MS27039-1-13	Screw	16 Ea (1 ea)	180-Small Fab - 2 - B4B	S006972
NAS1149D0332J	Washer	48 Ea (3 ea)	180-Small Fab - 2 - B4B	S222100

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D6201	16	17	0
180-Small Fab - 2 - B4B	D2372	32	16	0
	D2444	16	3	0
	MS21042L3	16	2,767	0
	MS27039-1-13	16	286	0
	NAS1149D0332J	48	1,498	0

Part Specifications

Specifications could not be found.

Plex 10/23/19 1:35 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 202279
Description: Fwd Litter Tie Down Bracket		Part Number: D3179-1
Inspection Dwg: D3179	Rev: E	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.00	✓		U2V	SC-04
R0.40	+/-0.030	R0.40	✓		R/G	REF
R0.38	+/-0.030	R0.38	✓		R/G	
1.70	+/-0.030	1.70	✓		H.G.	31006
Ø0.191	+0.005/-0.001	Ø0.191	✓		G.P.	REF
10.500	+/-0.010	10.500	✓		H.G.	REF
4.250	+/-0.010	4.250	✓		U2V	SC-04
Ø0.246	+0.005/-0.001	Ø0.245	✓		G.P.	REF
1.50	+/-0.030	1.50	✓		U2V	
0.750	+/-0.010	0.750	✓		U2V	↑
1.000	+/-0.010	0.998	✓		U2V	↑
4.00	+/-0.030	4.00	✓		U2V	SC-04
1.00	+/-0.030	1.002	✓		H.G.	REF
1.38	+/-0.030	1.38	✓		U2V	SC-04
1.875	+/-0.010	1.879	✓		H.G.	↑
2.125	+/-0.010	2.128	✓		H.G.	REF
2.88	+/-0.030	2.865	✓		U2V	↑
3.31	+/-0.030	3.307	✓		U2V	SC-04
R0.375	+/-0.010	R0.375	✓		R.G.	↑
R0.50	+/-0.030	R0.50	✓		R.G.	↑
Ø0.191	+0.005/-0.001	Ø0.191	✓		G.P.	REF
R0.25	+/-0.030	R0.25	✓		R.G.	REF
R0.375	+/-0.010	R0.375	✓		R.G.	↓
R0.38	+/-0.030	R0.38	✓		R.G.	↓
12.00	+/-0.030	12.00	✓		H.G.	31006
9.000	+/-0.010	8.999	✓		H.G.	↓
7.50	+/-0.030	7.50	✓		U2V	SC-04
4.50	+/-0.030	4.50	✓		U2V	↓
2.88	+/-0.030	2.875	✓		U2V	↓
2.250	+/-0.010	2.249	✓		H.G.	31006
1.000	+/-0.010	0.998	✓		U2V	SC-04
0.50	+/-0.030	0.498	✓		U2V	↓

Measured by: DAS 52	Checked by: DAS 23	QC Inspector:
Date: 9-89 19/10/05	Date: 9-89 19/11/07	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue P/O D3179-041	KJ/DD	
B	12.10.04	Dimension 0.750 was 1.750	KJ	
C	13.05.27	Dimensions revised per Dwg Rev D	KJ	
D	16.06.08	Dimensions revised per Dwg Rev E	KJ	
E	17.02.16	Dimensions rearranged	KJ	



Container No: S231300



Part: D3179 - 041

Job No: 202279 - A

Serial No/Batch: S229184

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/03/20